

Work Order ID 62803

Friday, October 08, 2010 10:37:06 AM



Page 1

Item ID:	D4092-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Maintenance Step Assembly					
Start Date:	10/8/2010	Start Qty:	1.00	Cust Item ID:		
Required Date:	10/15/2010	Req'd Qty:	1.00	Customer:		

Reference:

Approvals:	Process Plan:	Date:	10-10-08	Tooling:		Date:		Run	Start	
	QC:	Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4092	A								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110		0.00							
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg Torque screws up to 15-25 in- lbs								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

10/11/02 (1)

10/11/03 (1)



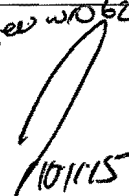

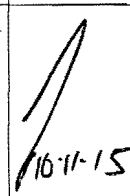
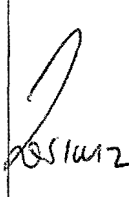
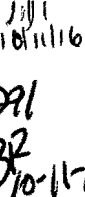


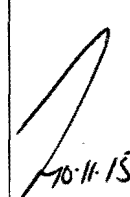
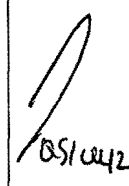
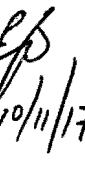

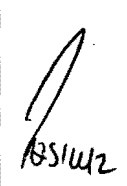
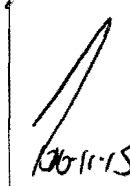
Y0
2012

(P70)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: Small parts NCR: Yes No DQA: _____ Date: _____

Resolution: re-work Disposition: re-work QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-11-15	110	D4693-1 & -3 Brackets (-1 B62563/-3 B62567) have water jet chatter along the parts. Chatter was caused by the process, but parts should have been reworked smooth. Re: Lack of attention		re-work the -1 & -3 Brackets to remove the chatter marks. Ensure thickness's are still in accordance to the dwg.	 10/11/15	See WO B62562  10/11/15	 10/11/15	 10-11-15
				Touch-up men's with pladine & re powder coat white. start: <u>9:30</u> Batch <u>M115391</u> Finish: <u>3:20</u> Temp: <u>10:00</u>	 10/11/16	S  10/11/16	 10/11/16	 10-11-15
				re-assemble step per dwg	 10/11/17	S  10/11/17	 10/11/17	 10-11-15






NOTE: Date & initial all entries

Work Order ID 62803



Friday, October 08, 2010 10:37:06 AM





Page 2

Item ID: D4092-042 Accept  Setup Start 
Revision ID: Stop 
Item Name: Maintenance Step Assembly
Start Date: 10/8/2010 Start Qty: 1.00  Cust Item ID:
Required Date: 10/15/2010 Req'd Qty: 1.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Identify as per dwg & Stock Location: _____ Memo <i>ppp 63157</i>	0.00							
Packaging									
140  QC	QC21- Final Inspection - Work Order Release Memo	0.00							
Quality Control									

10.11.18 test only
- with approved drawings D4093-5 62569
- D4092-1 Rev PB1 63047
U 10.11.17

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY







Friday, October 08, 2010 10:37:10 AM

[illegible]

Start Qty: ~~1.00~~

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 10-10-08 JLM VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1 		Manufactured	No				Each	0.0000	2				
Maintenance Step													
D4093-1 		Manufactured	No				Each	0.0000	1				
Bracket													
D4093-3 		Manufactured	No				Each	0.0000	1				
Bracket													
D4093-5 		Manufactured	No				Each	0.0000	2				
Bracket													
MS24694-S54 		Purchased	No				Each	72.0000	2				
Screw													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST289			72						
				113359			1						
				115531			71						
MS24694-S55 		Purchased	No				Each	77.0000	8				
Screw													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST289A			77						
				13884			77						

Picklist Print

Friday, October 08, 2010 10:37:10 AM

Work Order ID: 62803

Parent Item: D4092-042

Parent Item Name: Maintenance Step Assembly

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 1.00 *2*

Required Qty: 1.00

MS24694-S56

Purchased

No

Each

110.0000

2



SCREW



Location

Loc Qty

Loc Code

ST289A

110

104407

110

Each

603.0000

12

NAS1149D0332J

Purchased

No



Washer



Location

Loc Qty

Loc Code

ST298

603

110985

12

114348

126

114884

265

114962

200

MS21042L3

Purchased

No

Each

2,546.000

12



Nut



Location

Loc Qty

Loc Code

ST300

2546

114523

49

114784

1497

115835

1000

M104407

1227

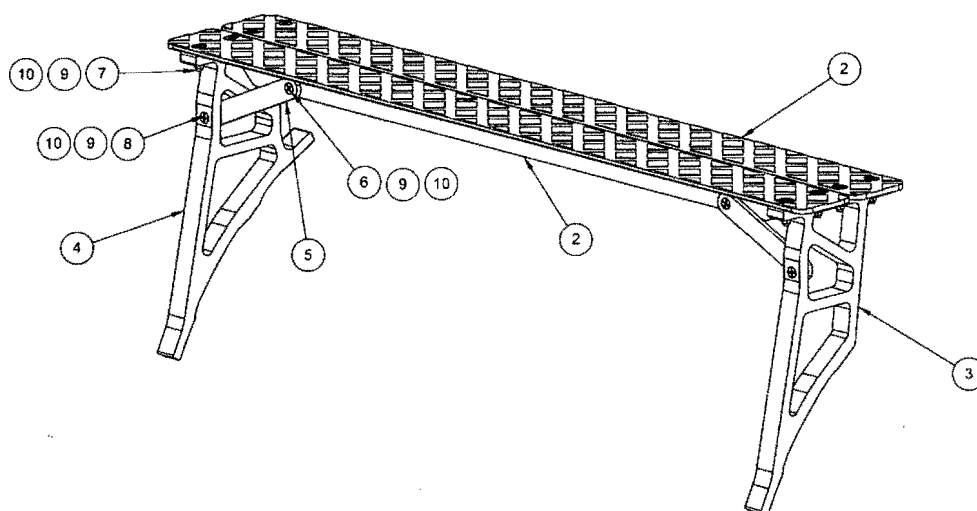
M114348

1227

M114784

10/11/02 (2)

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	2	MS24694-S54	SCREW
7	8	MS24694-S55	SCREW
8	2	MS24694-S56	SCREW
9	12	NAS1149D0332J	WASHER
10	12	MS21042L3	NUT

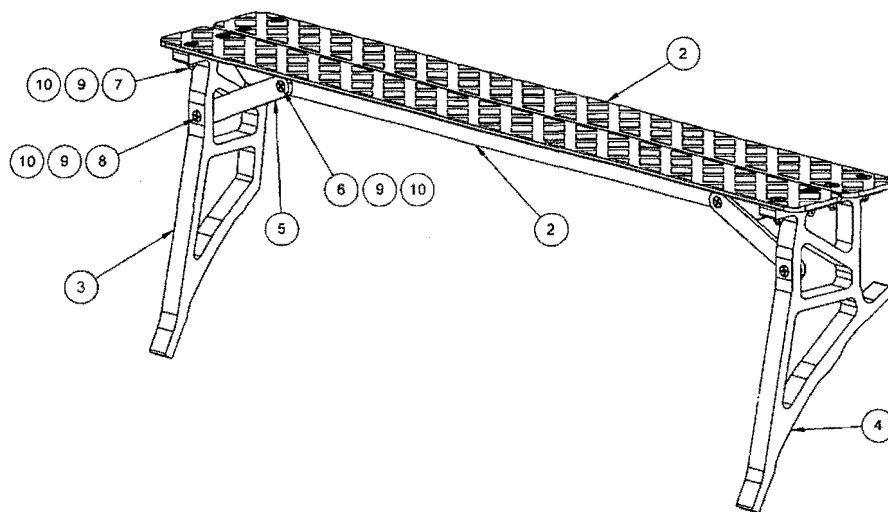


D4092-041 MAINTENANCE STEP ASSY

STOP
FOR
Y
UNCO
STU
NO. 62803
B/10-10-05

RELEASED
R 2010-09-23

A		NEW ISSUE		RF	10.09.16
REV.		DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA		REV. A	
DRAWN	RF			SHEET 1 OF 6	
CHECKED	<u>10</u>	DRAWING NO. D4092		SCALE	
MFG. APPR.	<u>10</u>	TITLE		NTS	
APPROVED	<u>10</u>	MAINTENANCE STEP ASSY			
DE APPR.	<u>10</u>	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			
DATE	10.09.16				



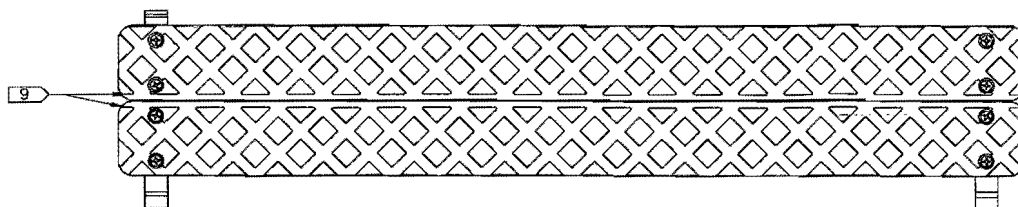
ITEM	QTY -042	PART NUMBER	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASS'Y
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	2	MS24694-S54	SCREW
7	8	MS24694-S55	SCREW
8	2	MS24694-S56	SCREW
9	12	NAS1149D0332J	WASHER
10	12	MS21042L3	NUT

D4092-042 MAINTENANCE STEP ASS'Y

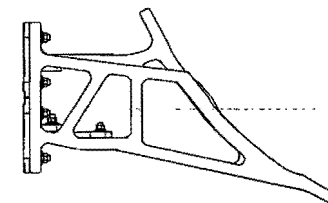
w/o 62503

RELEASED
2010-08-23
WV

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DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>MP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>MP</i>	D4092	SHEET 2 OF 6
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	MAINTENANCE STEP ASS'Y	NTS
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D4092-1
MAINTENANCE STEP



D4093-3
BRACKET

8
INSTALL
MS24694-S56 SCREW
NAS1149D0332J WASHER
MS21042L3 NUT
2 PL

8
INSTALL
MS24694-S54 SCREW
NAS1149D0332J WASHER
MS21042L3 NUT
2 PL

D4093-5 BRACE
2 PL

8
INSTALL
MS24694-S55 SCREW
NAS1149D0332J WASHER
MS21042L3 NUT
4 PL PER SIDE

D4093-1
BRACKET

w/o 62803

RELEASED
2010-09-23
JD

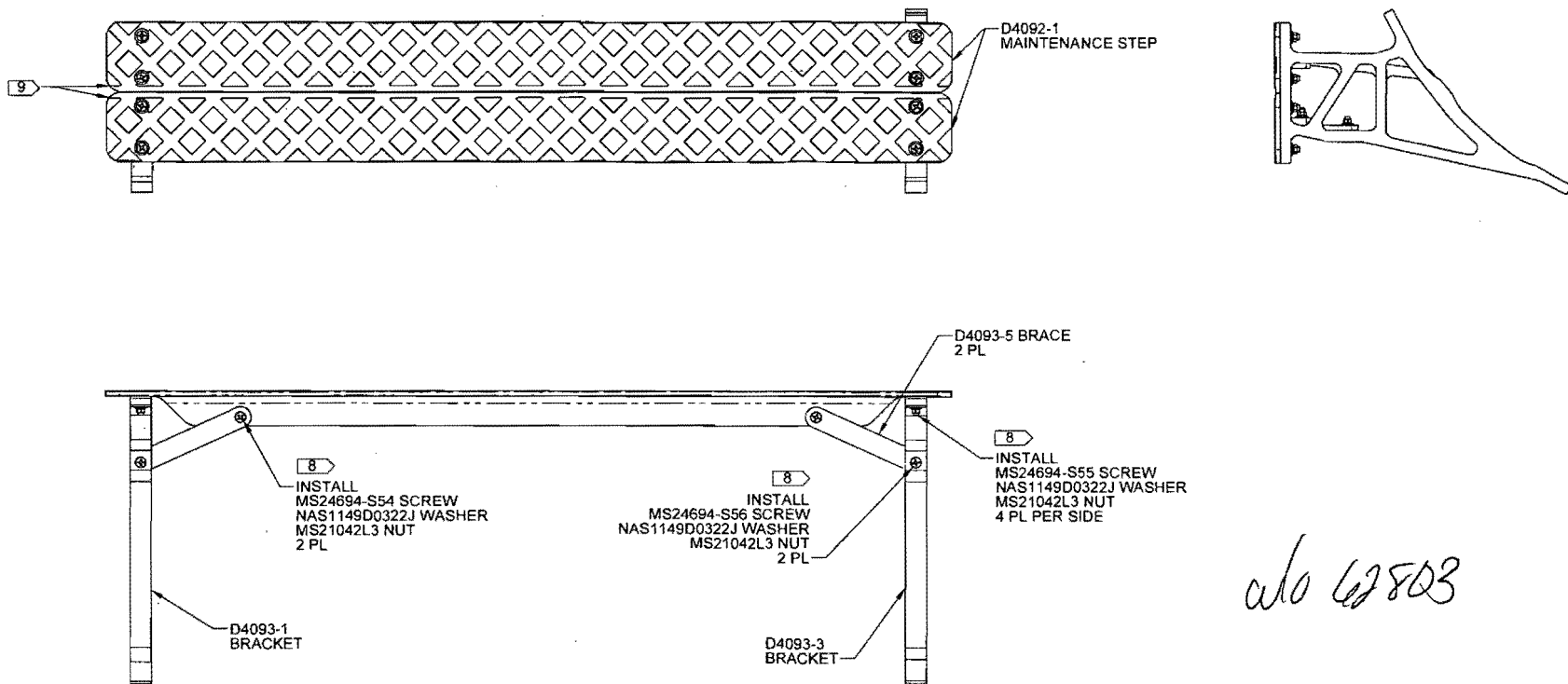
D4092-041 MAINTENANCE STEP ASS'Y

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 6.01 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>MP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>MP</i>	D4092	SHEET 3 OF 6
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	MAINTENANCE STEP ASS'Y	NTS
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8 7 6 5 4 3 2 1



WLO 62803

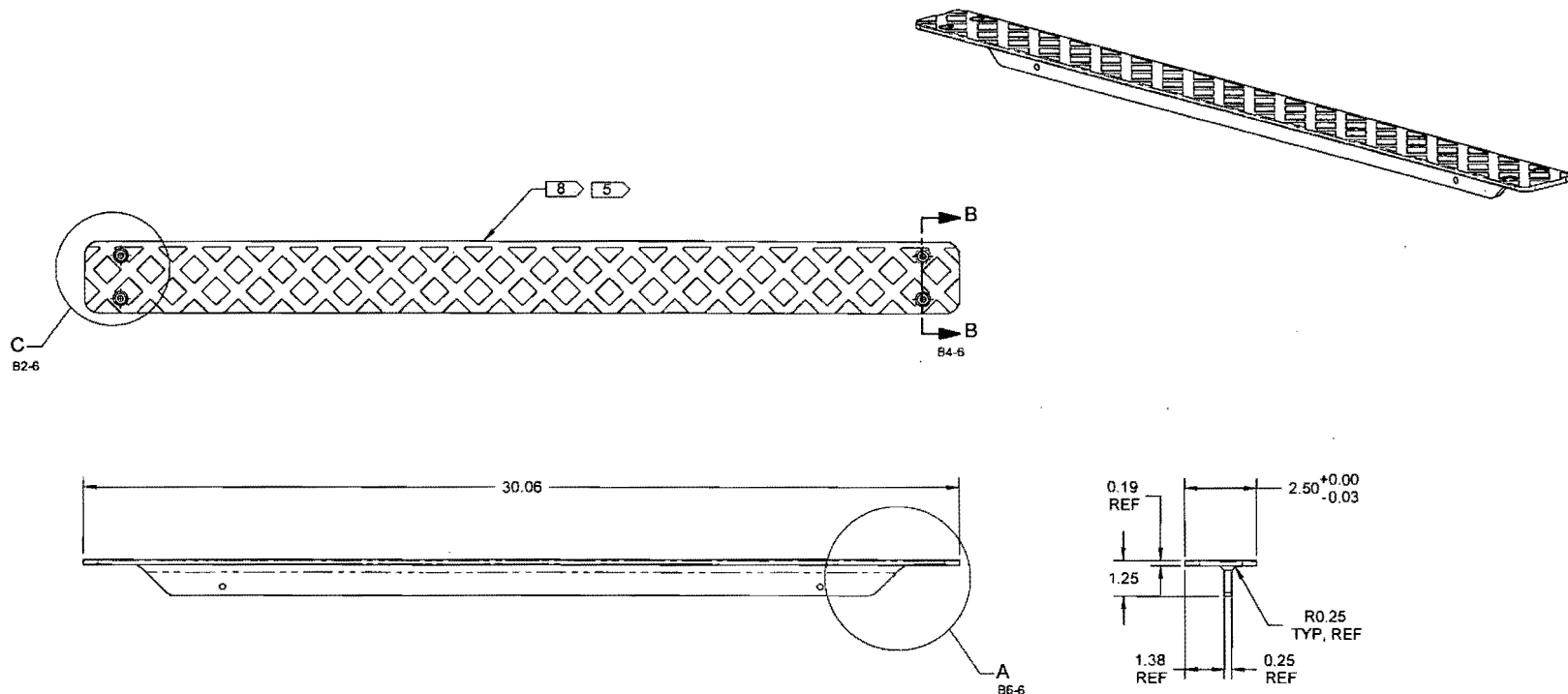
D4092-042 MAINTENANCE STEP ASS'Y

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER QSI 044 6.1
 - 7) WEIGHT: 5.99 lbs
 - 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
 - 9) GRIP CUTOUT TOWARD CENTER

RELEASED
2010-09-23

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4092	SHEET 4 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASS'Y	NTS
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8 7 6 5 4 3 2 1



D4092-1 MAINTENANCE STEP
(MAKE FROM D2761 EXTRUSION)

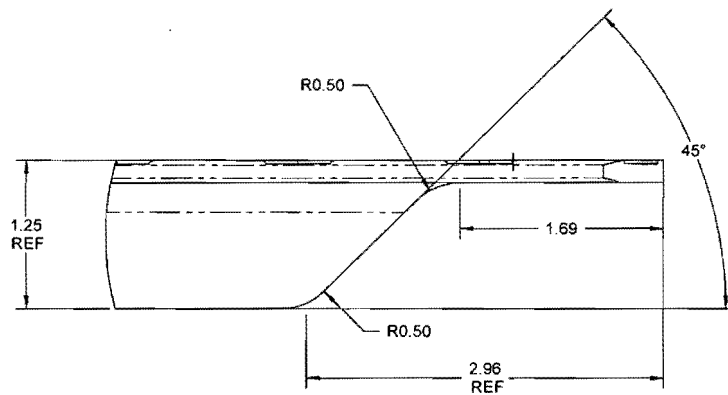
NOTES:

- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4
MASK SPOT FACE HOLES PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

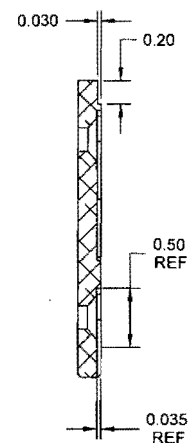
w/ 62803

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2010-09-23

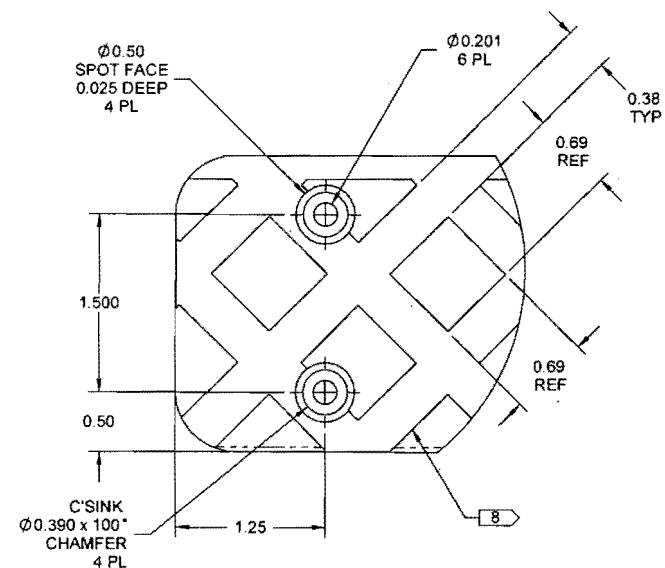
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DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4092	SHEET 5 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASS'Y	NTS
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DETAIL A
SCALE 4X, TYP







SECTION B-B
SCALE 4X, TYP



DETAIL C
SCALE 4X, TYP

W/C 62803

RELEASE
2010-09-23

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4092	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		MAINTENANCE STEP ASS'Y NTS	
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